

6061-T6 Tube 0.375 X.058 w

Work Order ID 77574

77574

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December-13-11 1:45:05 PM

Item ID: D2649 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cross Bolt Spacer
 Start Date: 13/12/2011 Start Qty: 400.00 *400* Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 400.00 *400* Customer:
 Reference:

Approvals: Process Plan: M.L.J. Date: 11/12/13 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2649	Rev B1								

100 0.00
 100 Hardinge CNC LATHE SMALL 400 0 11/12/28
 Hardinge Memo 0.00
 Hardinge CNC Lathe Small Machine as per folio FA214 on cobra machine.

110 0.00
 110 QC2- Inspect parts off machine FAI/FAIB 400 0 11/12/28
 QC Memo 0.00
 Quality Control

120 0.00
 120 QC8- Inspect parts - second check 400 0 11/12/28
 QC Memo 0.00
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

400

Cust Item ID:

400

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

125

Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

130

Identify as per dwg & Stock Location: LG

0.00

130

Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

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Picklist Print

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Work Order ID: 77574

77574

Parent Item: D2649

D2649

Parent Item Name: Cross Bolt Spacer

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 400.00

Required Qty: 400.00

Comments:

IPP F02.03.26Added turning on CobraNG
added cleaning DD verified :EC

IPP Rev:G 10.05.11

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.375W.058

Purchased

No

100

f

808.1300

0.2833

119.2842

M6061T6T0 375W 058

**

114.279'

11/12/28

6061-T6 RD Tube .375 x.058W

Location

Loc Qty

Loc Code

MAT014

808.13

116920

0.578

119087

13.685

119376

492

119644

1.867

119678

300

0.279'
114.000'

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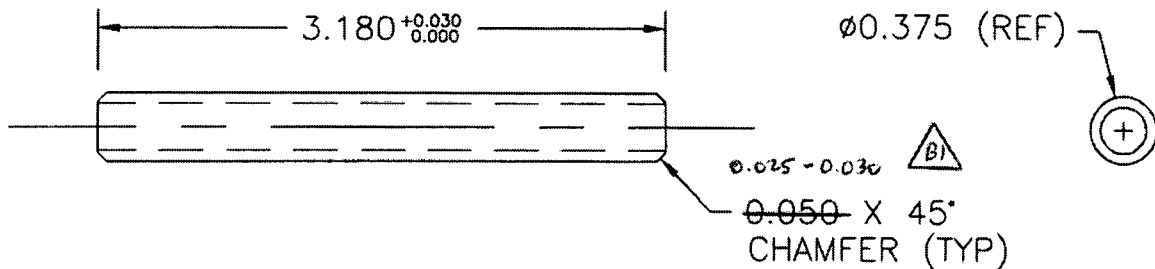
NOTE: Date & initial all entries



DESIGN <i>DM</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DM</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
B1	98.01.14 02.06.13	REDUCE CHAMFER PER TSR 1296.	

RELEASED
98.01.20 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77534 M.L.U
11/12/13



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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